

Date: Friday, 9/29/2006 10:43:16 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SPACER
Job Number : 28791A	
Estimate Number : 10352	
P.O. Number : <i>N/A</i>	Part Number : D2280
This Issue : 9/29/2006 S.O. No. : <i>N/A</i>	Drawing Number : D2280 REV D
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : SMALL / MED FAB	Drawing Revision : D
Previous Run : 27756A	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 10/10/2006 Qty: 40 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est Rev:A New Issue 05-11-07 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0250X01000	6061-T6 Bar .25" x 1.0"
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Comment: Qty.: 0.2975 f(s)/Unit Total : 11.8986 f(s)
 Material: 6061-T6 (QQ-A-250/8) 0.25" Thick
 (M6061T6B0.250x1.000) Identify as D2280
 Batch: *M18237*

[Signature] 06/10/03

2.0	SHEAR	SHEAR
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Comment: SHEAR
 Cut blank: (3.400") +/-0.020"

[Signature] 06/10/03 40

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine per folio D2280 and Dwg D2280

2-Deburr Then Tumble

[Signature] 06/10/19 40

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

[Signature] 06/10/19 40

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

[Signature] 06/10/20 x 40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ _____ Date: 06/10/24

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

YF 06/10/20 x 40

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 06 10 23 (40)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5736

P. 4/10/23 (40)

9.0

QC21

FINAL INSPECTION W/O RELEASE



Comment: FINAL INSPECTION W/O RELEASE

06/10/24 (40)

Job Completion



u 06-10-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

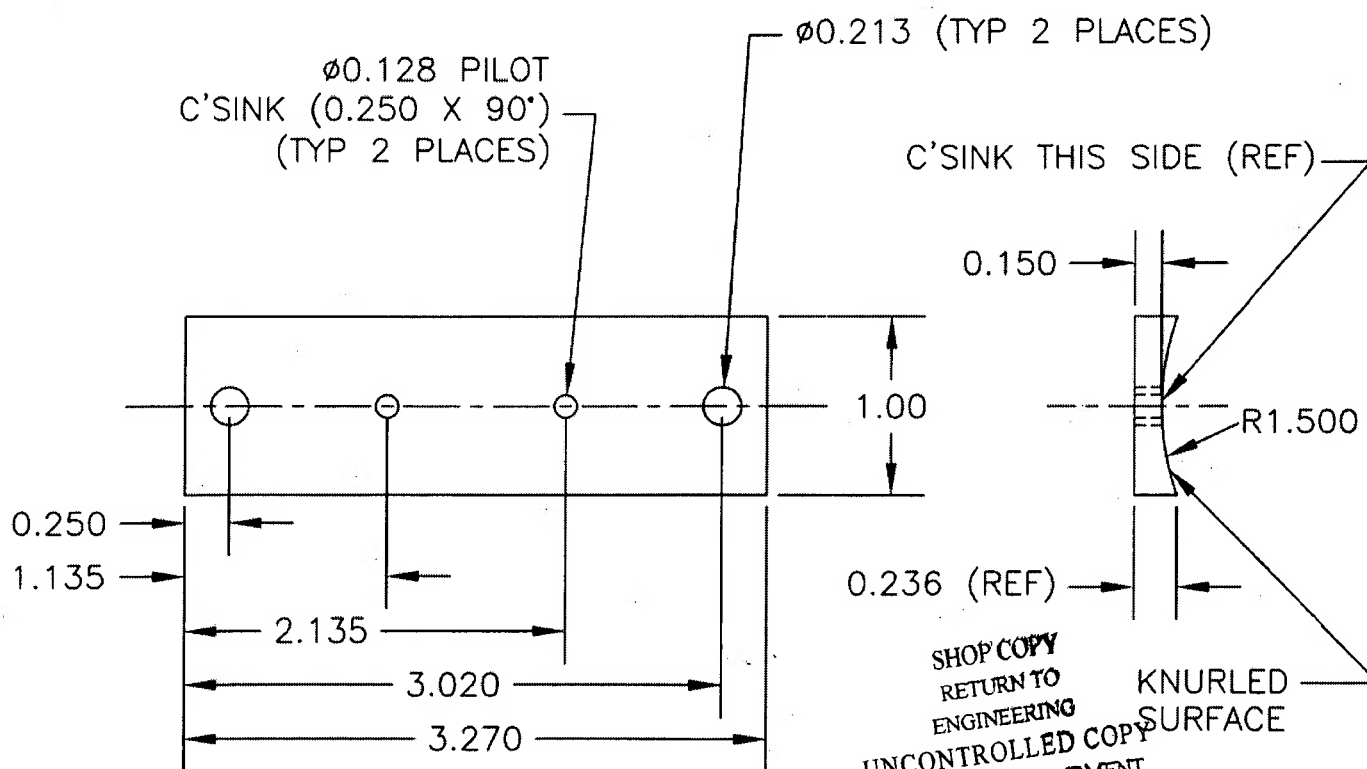
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN #	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2280	REV. D SHEET 1 OF 1
DATE 05.11.14		TITLE SPACER	SCALE 1:1
A	94.10.14	NEW ISSUE	
B	95.03.22	MATERIAL CHANGE, 0.15 WAS 0.20	
C	98.09.29	0.188 DIA HOLE CHANGED TO 0.213	
D	05.11.14	ADD FINISHING NOTE	

RELEASED
05.11.28**D2280 SPACER**

- 1) MATERIAL: ALUMINUM 6061-T6 (QQ-A-200/8) BAR, 0.250 X 1.000 (REF. DART SPEC M6061T6B1.000X00.250)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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